

Date: Wednesday, 1/23/2008 11:36:05 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	MIRROR BRACKET		
Job Number	36919A					
Estimate Number	10143					
P.O. Number	:		Part Number	D20135		
This Issue	1/23/2008	S.O. No. :	Drawing Number	D2013 REV C		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	C		
Previous Run	36886A		Material	:		
Written By	:		Due Date	1/30/2008	Qty:	5 Um: Each
Checked & Approved By	:					
Comment	Est Rev:A New Issue 05-11-01 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825,f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing (M304TR0.750W.049) Batch: M107 093 (5) 8B 08/02/12 (5)		
2.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Punch as per template D2013-T5 and Dwg D2013 2-Flatten ends of D2013-5 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201Identify as D2013-5. 4-Deburr as required 8B 08/02/12 (5) FF 08-02-13 (5) FF 08-02-15 (5) FF 08-02-13 (5)		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP 8B 02.20 (5)		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 8B 02.20 8		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:05 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36919A

Part Number: D20135

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



(S)

Comment: FINAL INSPECTION/W/O RELEASE

Doel 02/20

Job Completion



- 2008/2/20 (S)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

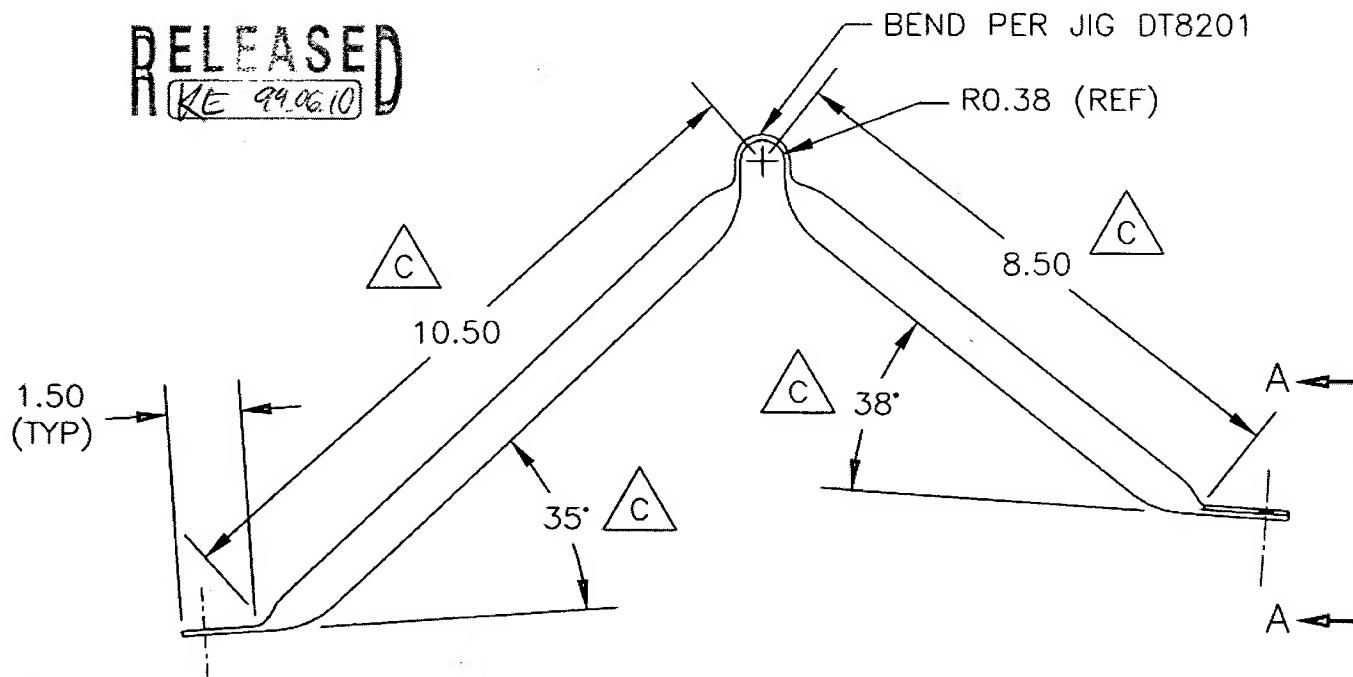
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

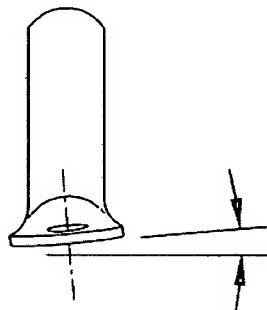
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**RELEASED**  
KE 99.06.10



D2013-1 LH SHOWN  
D2013-2 RH OPPOSITE  
(FOR 205 MIRROR)



VIEW A-A

SHOP COPY  
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ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO  
NO 3699A

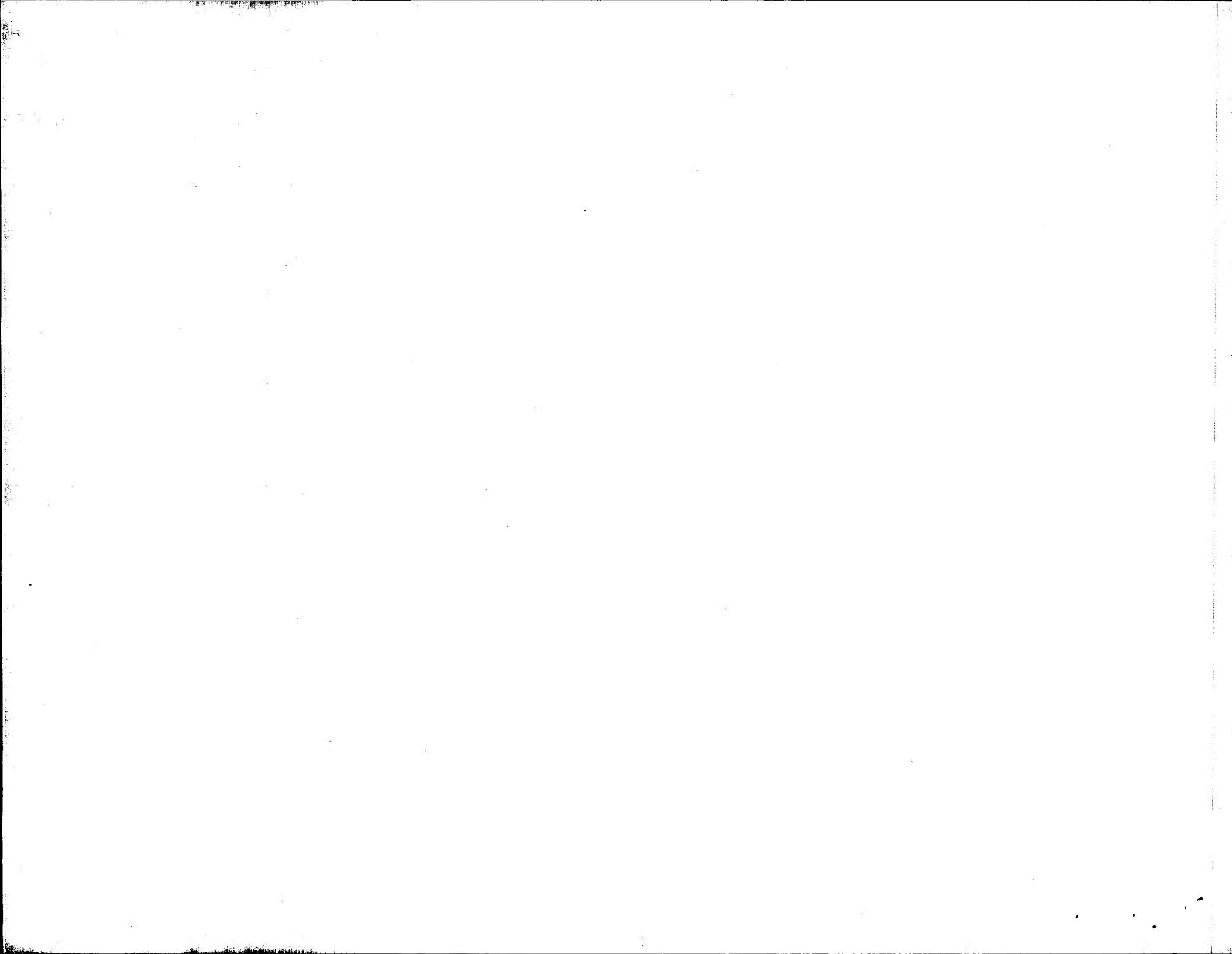
CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

**DART**

DA COPY  
SERIAL

DESIGN JB.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED KE	APPROVED JF	DRAWING NO. D2013	SHEET 1 OF 3
DATE 99.06.07	TIME 90.10.22	MIRROR BRACKET	SCALE NTS
A	94.06.15	REDRAWN	
B			
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS	



**RELEASED**

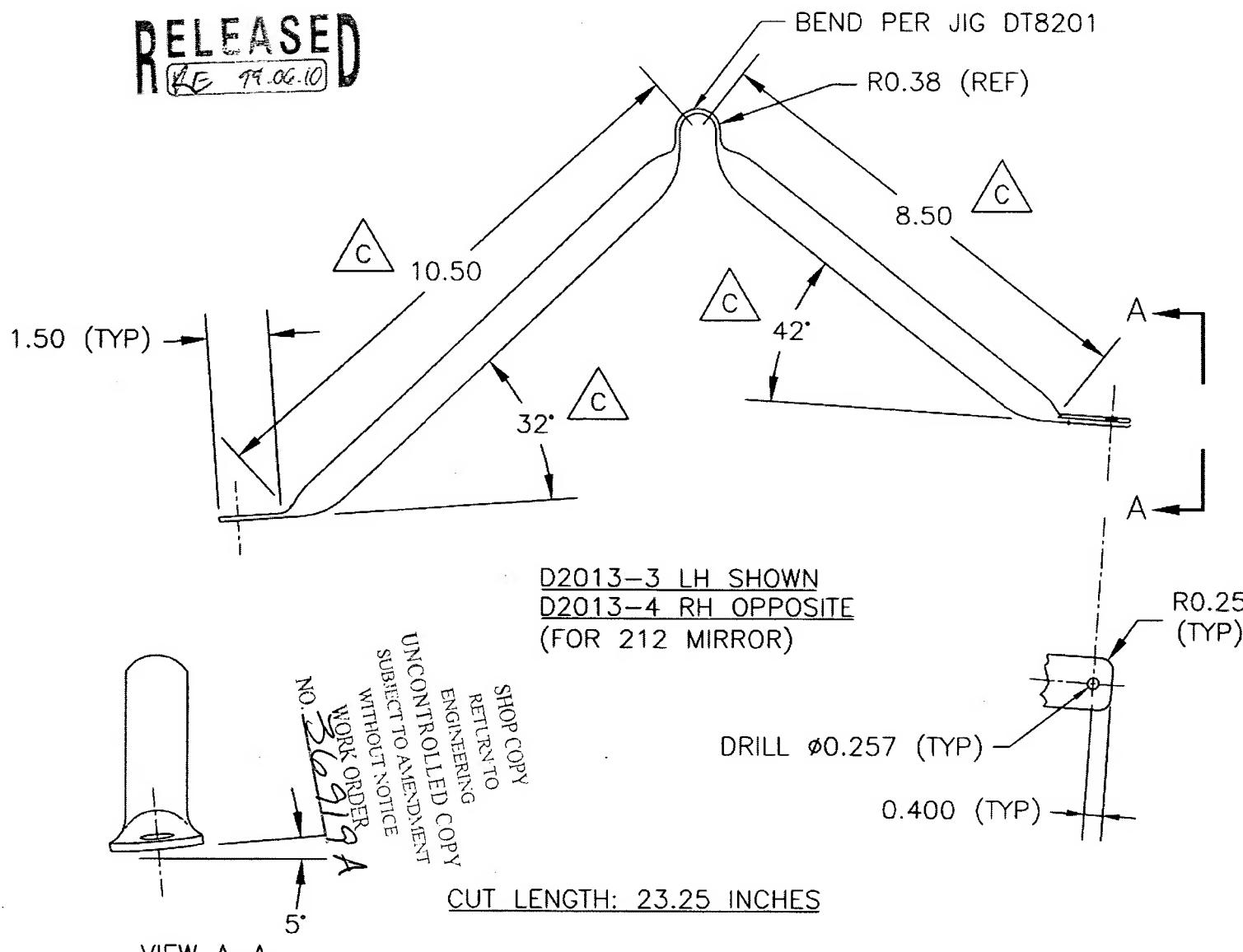
RE 99.06.10

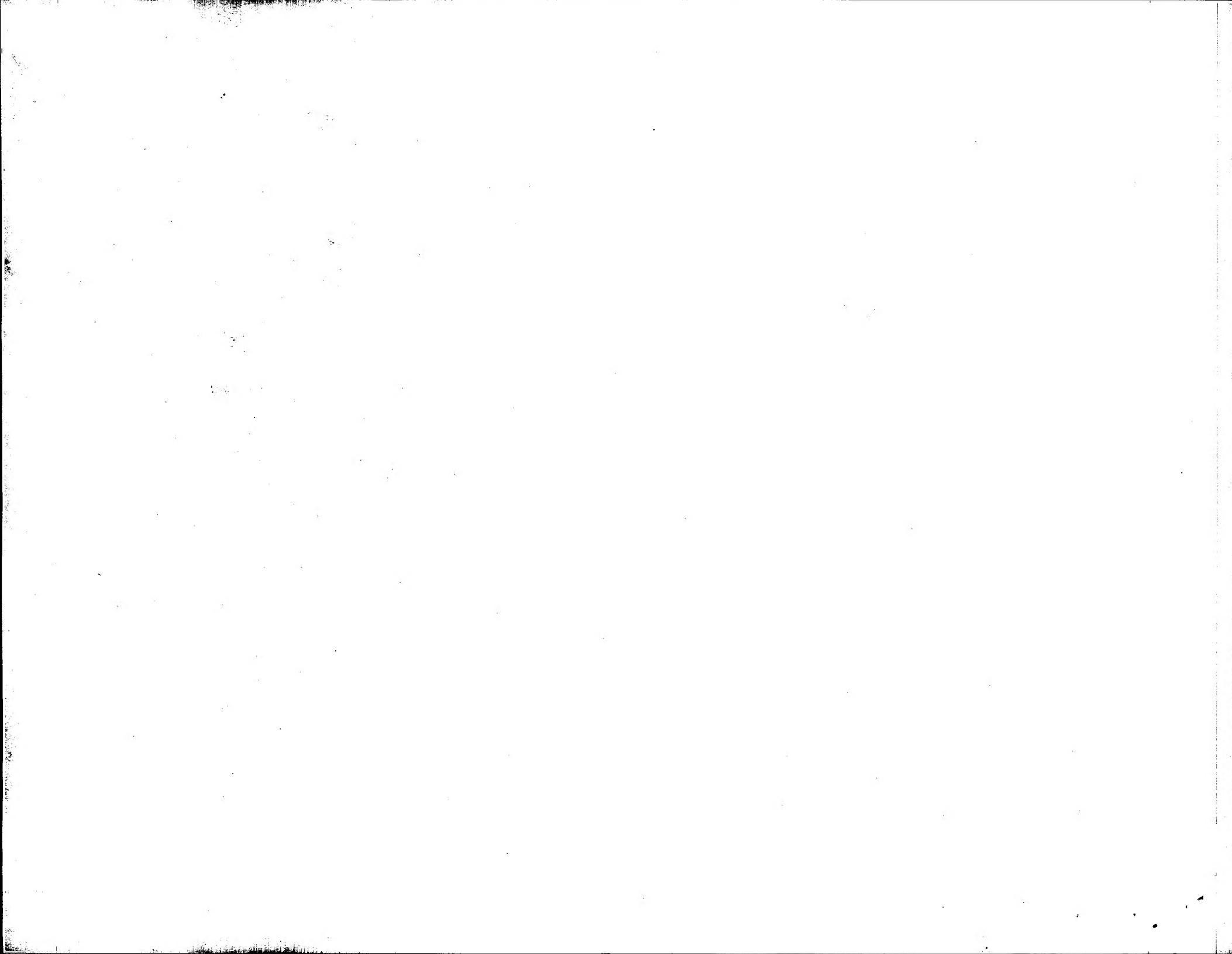
**DART**



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED RE	APPROVED <i>[Signature]</i>	DRAWING NO. D2013
DATE 99.06.07		TITLE MIRROR BRACKET

REV. C  
SHEET 2 OF 3  
SCALE  
NTS



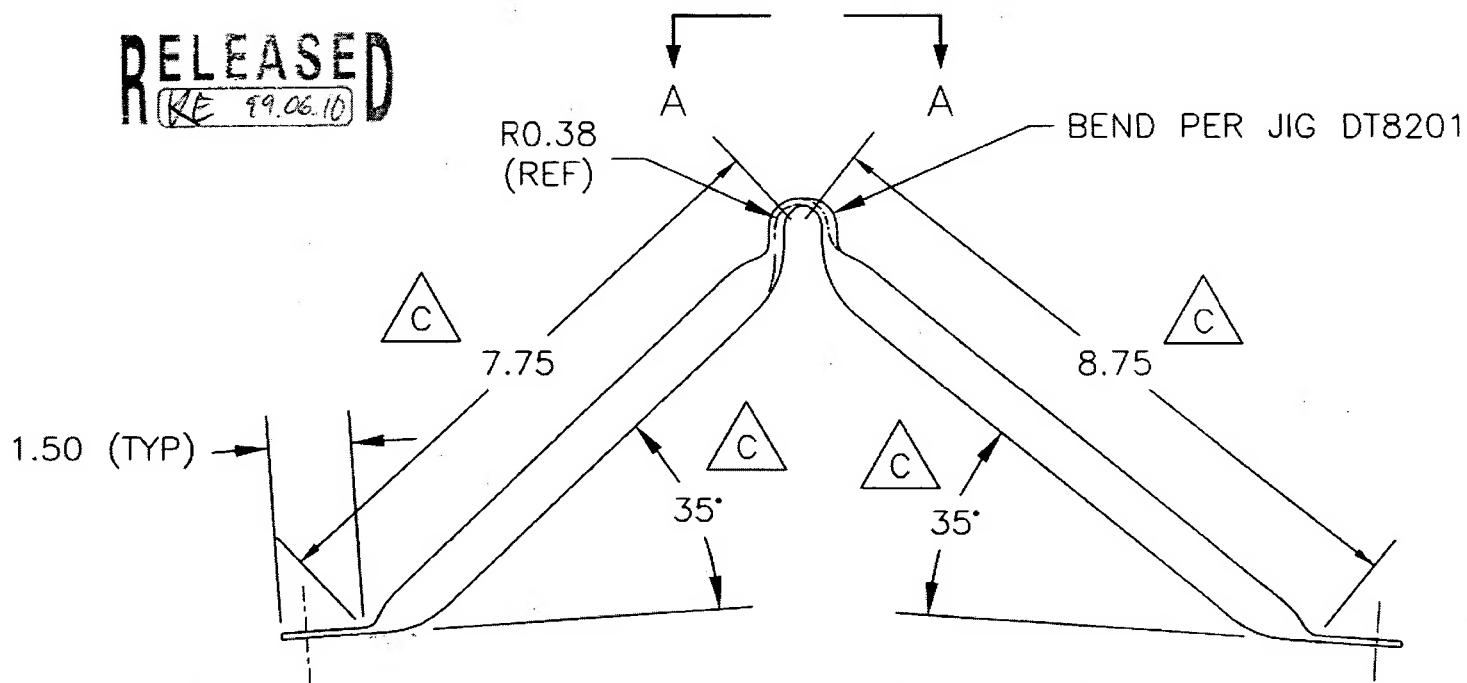


**RELEASED**  
RE 99.06.10

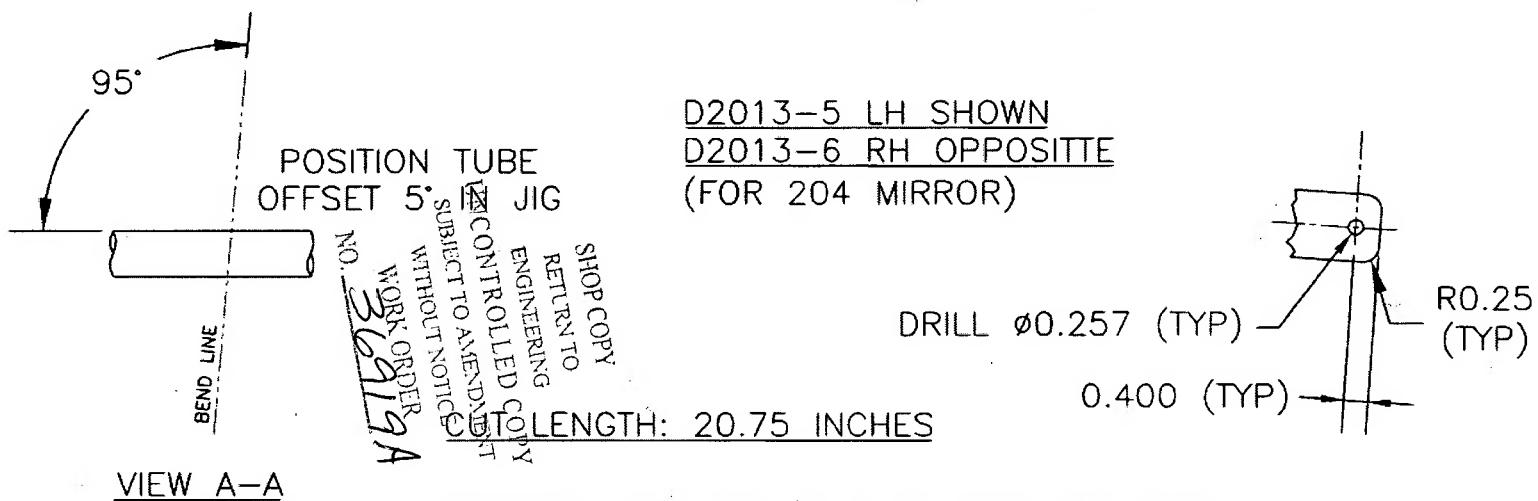
**DART**



DESIGN NO.	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
RE 99.06.07	DATE	REV. C
D2013	TITLE	SHEET 3 OF 3
MIRROR BRACKET	SCALE	NTS



D2013-5 LH SHOWN  
D2013-6 RH OPPOSITE  
(FOR 204 MIRROR)



VIEW A-A

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 O.D. x 0.049 WALL

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WITHOUT NOTICE  
WORK ORDER  
NO. 3619A

LENGTH: 20.75 INCHES

Date: Wednesday, 1/23/2008 11:36:29 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	36919C		
Estimate Number	10145		
P.O. Number		Part Number	D2037101
This Issue	1/23/2008	S.O. No.	D2037 REV C3
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	C3
Previous Run	36909	Material	
Written By		Due Date	1/30/2008
Checked & Approved By	<u>1/23/08</u>	Qty:	5 Um: Each
Comment	Est Rev:A New Issue 05-11-01 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049) Batch: <u>M107098</u>	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037	
		2-Flatten ends of D2037-101 tube as required using DT8545	
		3-Deburr as required	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Identify and Stock Location: <u>A3410</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 01/02/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 36919C

Part Number: D2037101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

1/23/2008 (2/20)

Job Completion



ini 2008 (2/20)

(5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

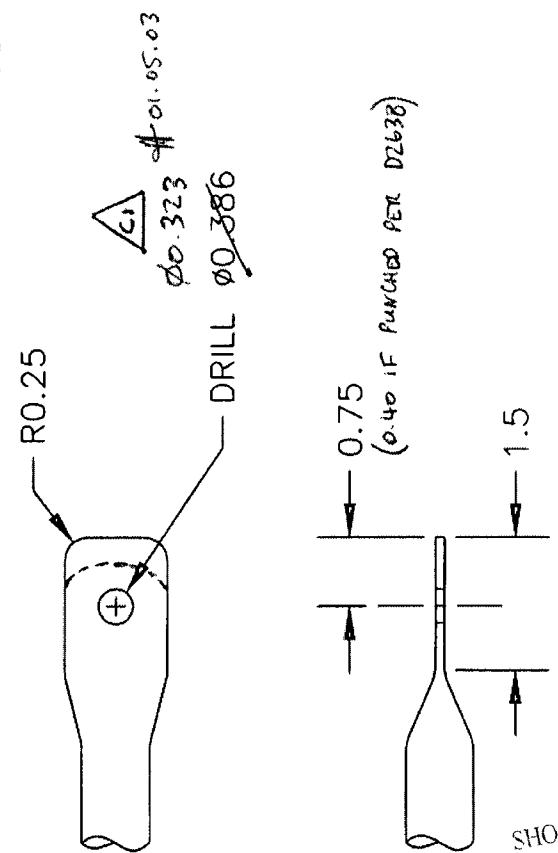
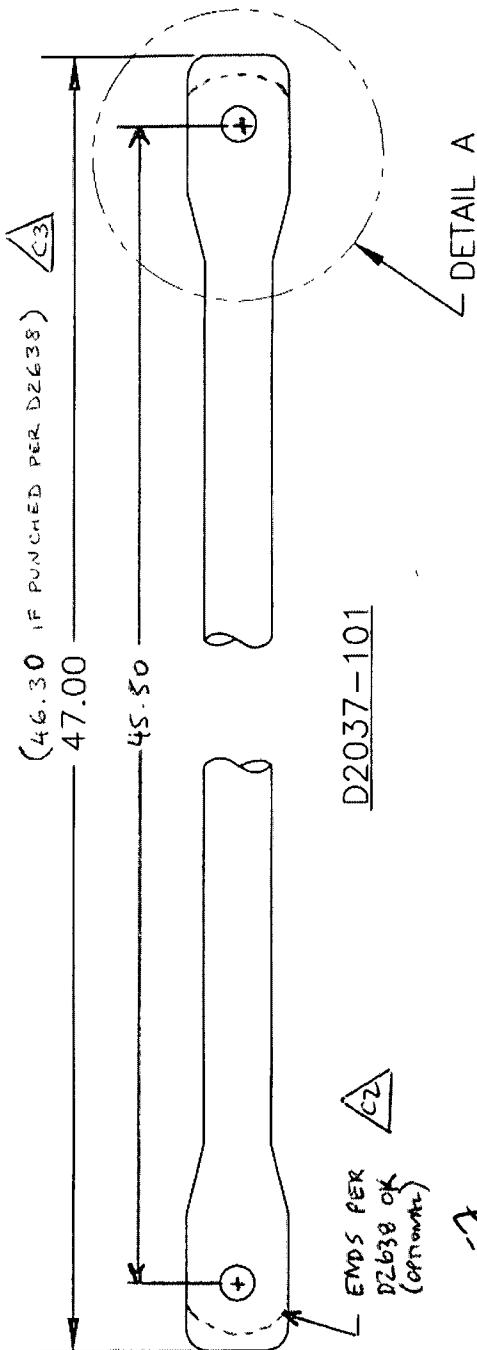
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



3 COPY ISSUED  
DETAIL

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2037
DATE 99.06.07	TITLE ARM	REV. C SHEET 1 OF 1
		SCALE NTS
A	91.10.22	NEW ISSUE
B	93.04.20	-103 DELETED
C	99.06.07	REDRAWN, 0.386 WAS 0.375
C1	<del>if ip</del> 01.05.03	CHANGE TO $\phi$ 0.323
C2	<del>if ip</del> 02.06.14	ADD PUNCH PER D2638 As option

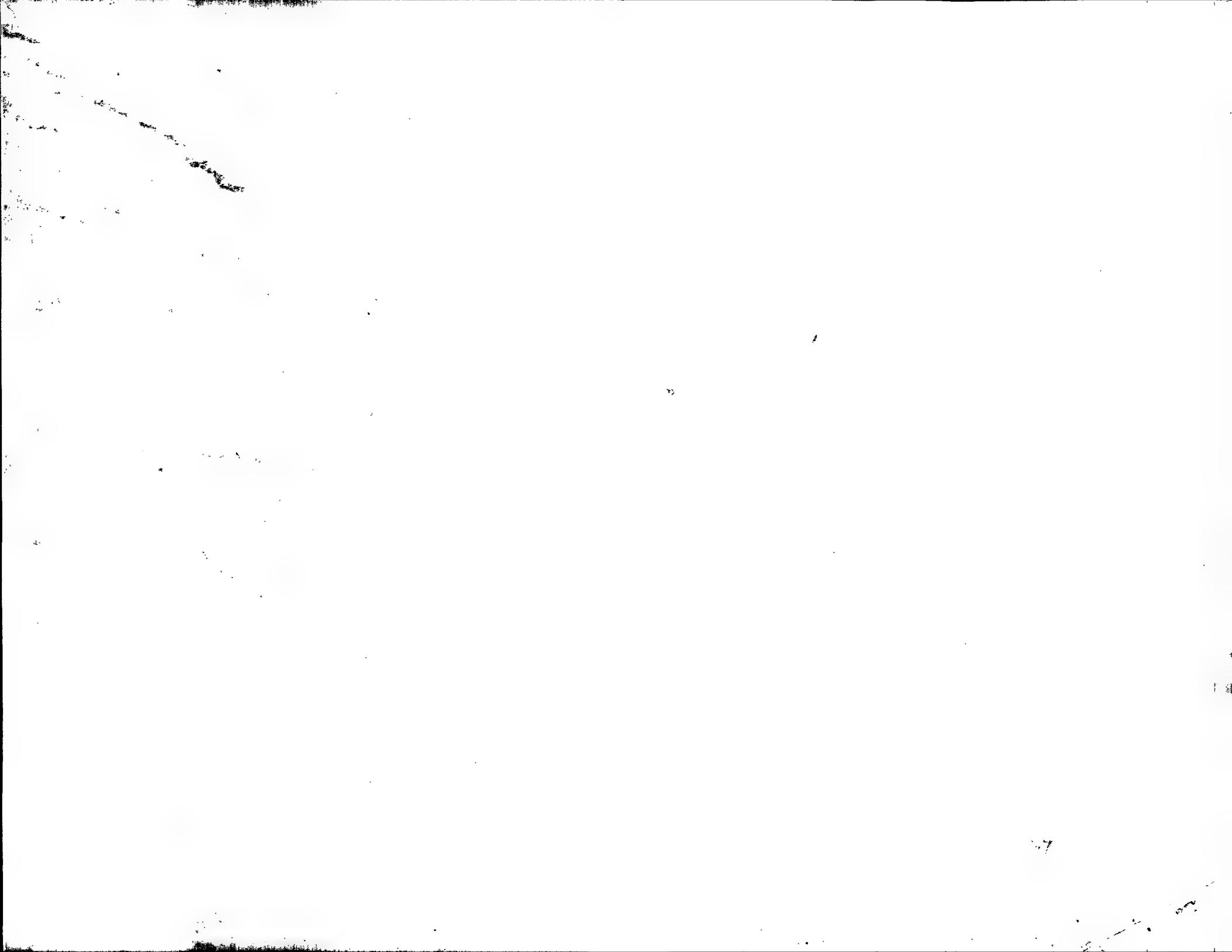


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KE 99.06.10

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WORK ORDER  
No. 36999C

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WALL

C3	<del>if ip</del> 05.04.27	ADD 46.30 PUNCHED PER D2638
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Date: Wednesday, 1/23/2008 11:36:17 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	MIRROR BRACKET		
Job Number	36919B					
Estimate Number	10144					
P.O. Number	:		Part Number	D20136		
This Issue	1/23/2008	S.O. No. :	Drawing Number	D2013 REV C		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	C		
Previous Run	36886B		Material	:		
Written By	:		Due Date	1/30/2008	Qty:	5 Um: Each
Checked & Approved By	HJ 08/01/23					
Comment	Est Rev:A New Issue 05-11-01 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube 750 x .049W
Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s) Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing (M304TR0.750W.049) Batch: M 105988 (2) M 107098 (3) SB 08/02/12 (5)		
2.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE 1-Punch as per template D2013-T5 and Dwg D2013 2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545 3-Bend tube as per Dwg D2013 using Jig DT8201Identify as D2013-6. 4-Deburr as required		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP Job 08-02-15 (5) PTO (4)		
4.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Job 08-02-20 (4)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2013 - 6 PAR #: N/A Fault Category: Prod/Fab Ass' <sup>made/brown</sup> NCR: Yes No DQA: *[Signature]* Date: 08/02/20 QA: N/C Closed: *[Signature]* Date: 08/02/20

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-02-20	20	1 part scrap. Bent incorrectly. R. c: Human error	<i>[Signature]</i>	Scrap - destroy - No replace	<i>F.F.</i> 08/02/20	<i>[Signature]</i> 08-02-20	<i>[Signature]</i>	<i>[Signature]</i> 08-02-20

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:36:17 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36919B

Part Number: D20136

Job Number:



Seq. #: Machine Or Operation:

Description :

50 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

1/23/2008 (4)

Job Completion



2008/2/20 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

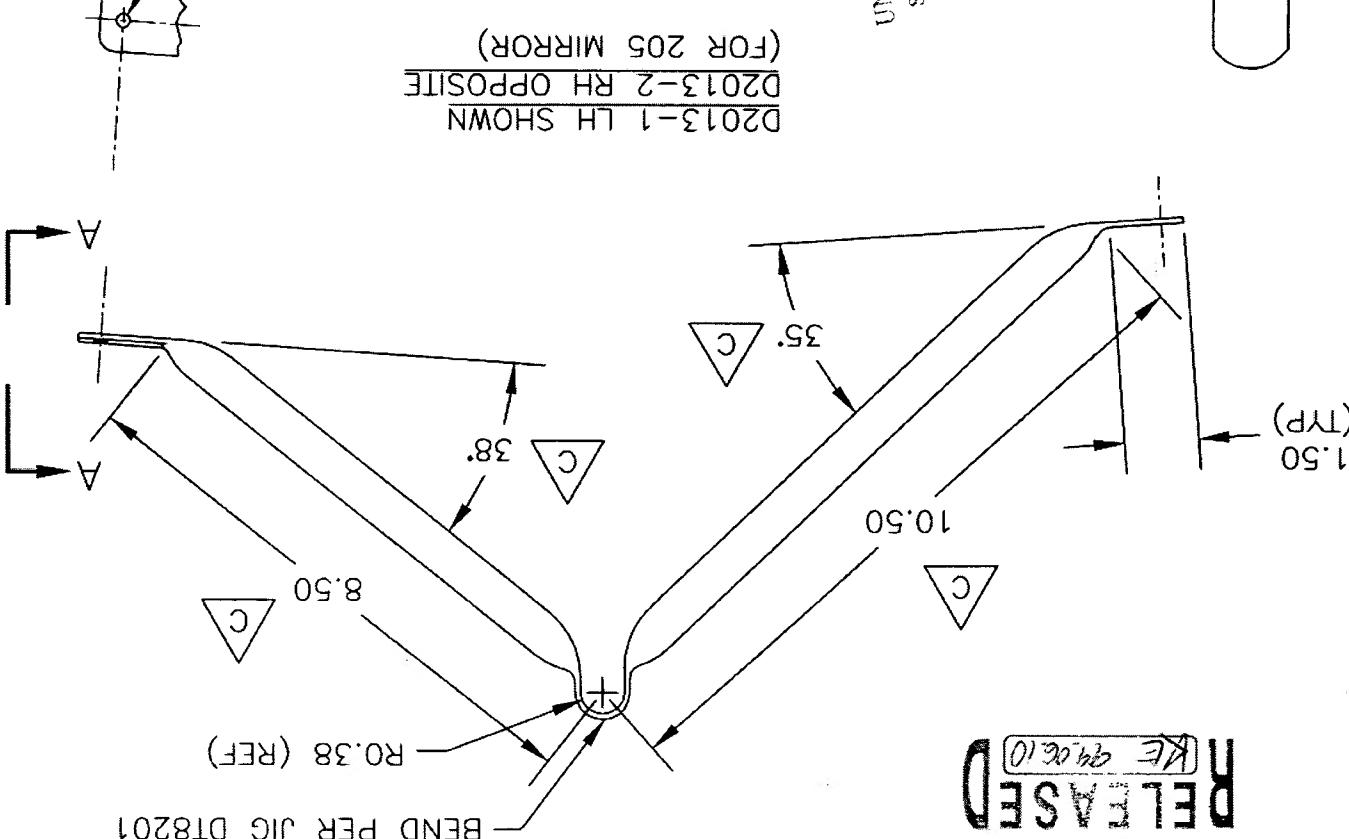
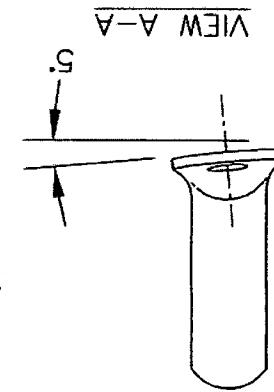


DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>KE</i>	APPROVED <i>Q</i>	DRAWING NO. D2013	SHEET 1 OF 3
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,  
0.750 OD x 0.049 WALL

CUT LENGTH: 23.25 INCHES

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *36919B*

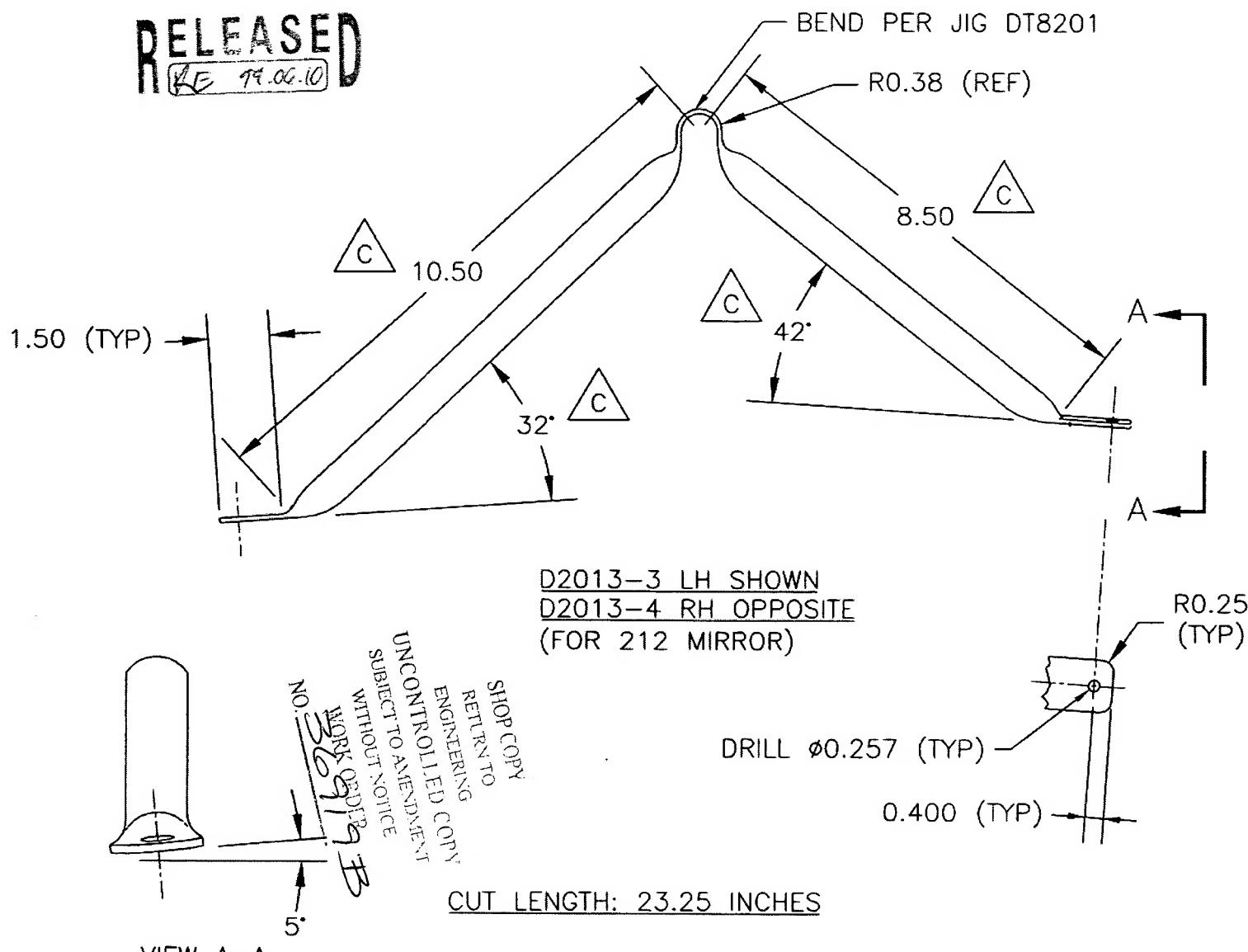


**RELEASED**  
RE 19.06.10

**DART**



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED <i>[Signature]</i>	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	REV. C SHEET 2 OF 3 SCALE NTS



**RELEASED**  
RE 99.06.10

**DART**



DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED RF	DRAWING NO. D2013
DATE 99.06.07		REV. C
	TITLE MIRROR BRACKET	SHEET 3 OF 3

